

Date: Monday, 05/01/2009 3:16:22 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LOW PROFILE BASKET LID ASS'Y
Job Number : 44377
Estimate Number : 13153
P.O. Number :
This Issue : 05/01/2009 S.O. No. :
Prsht Rev. : NC Part Number : D3713042
First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3713 REV B
Previous Run : 38763 Drawing Revision : B
Material :
Due Date : 26/01/2009 Qty: 1 Um: Each
Written By : W
Checked & Approved By :
Comment : Est Rev:A new issue 08-01-30 DD verified
by:EC
Est Rev:B change to revB ecn 1145 08-03-19 DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 32.5731 f(s)/Unit Total : 32.5731 f(s)
304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY PART NUMBER BATCH

2 D3714-1 B 110335
2 D3715-1 B 110335
10 D3716-1 B 110335 B110011 (9,08)
4 D3732-1 B 110335

2- Deburr

SAD 09-04-06

2.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

batch B40390 → 2x CPC09-01-06

3.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

batch B40895 → 2x 09/01/08

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Part Number: D3713042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	D37491	Hinge Half
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

✓ HINGE HALF

batch B38826 → 3x

Cpl 09-01-06

5.0	D2329	Label Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

* Label Plate

batch B35686 → 1x

SJ 09/01/08

6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- drill holes in both D3715-1 as per dwg D3715

2- deburr

3- assemble as per dwg D3713 and weld as per QSI004

Cpl 09-01-06

7.0	M304EX07516F	Expanded Metal Flat SS
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Comment: Qty.: 17.8500 sf(s)/Unit Total : 17.8500 sf(s)

Expanded Metal Flat Stainless Steel

✓ Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

17sq.ft	M304EX0.75-16F	Expanded Metal	<u>B110134</u>
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SAD 09-01-06

①

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh as per dwg D3743

2- weld mesh as per dwg D3713

SJ 09/01/08 ①x
EL 9-1-7 ②

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Part Number: D3713042

Job Number:



Seq. #: Machine Or Operation: Description :

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/08 (X)

10.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09/01/08

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m/05642

START TIME: 7:30
OVEN TEMPERATURE: 320°
FINISH TIME: 8:00

FZ 09/01/09

(1)

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-09

13.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: 1-Apply Wing Walk on mesh as per Dwg D3713 and QSI 005 4.4

Add D258-300-label-
2-apply armor shield over label on lid only

FZ 09/01/09 (1)

14.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-09

(2)

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

HAi Dms / sin

16.0 QC21 FINAL INSPECTION/W/O RELEASE

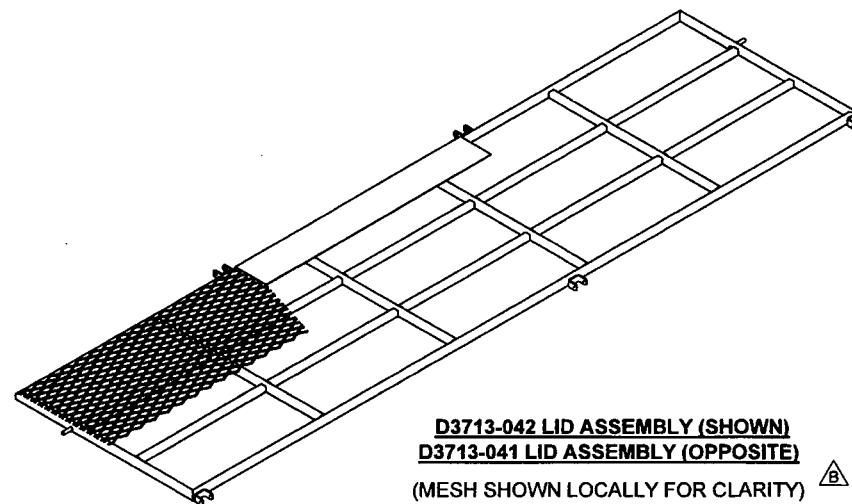


Comment: FINAL INSPECTION/W/O RELEASE

09/01/22

mf 09-01-21

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	MESH
3	3	D3749-1	HINGE HALF

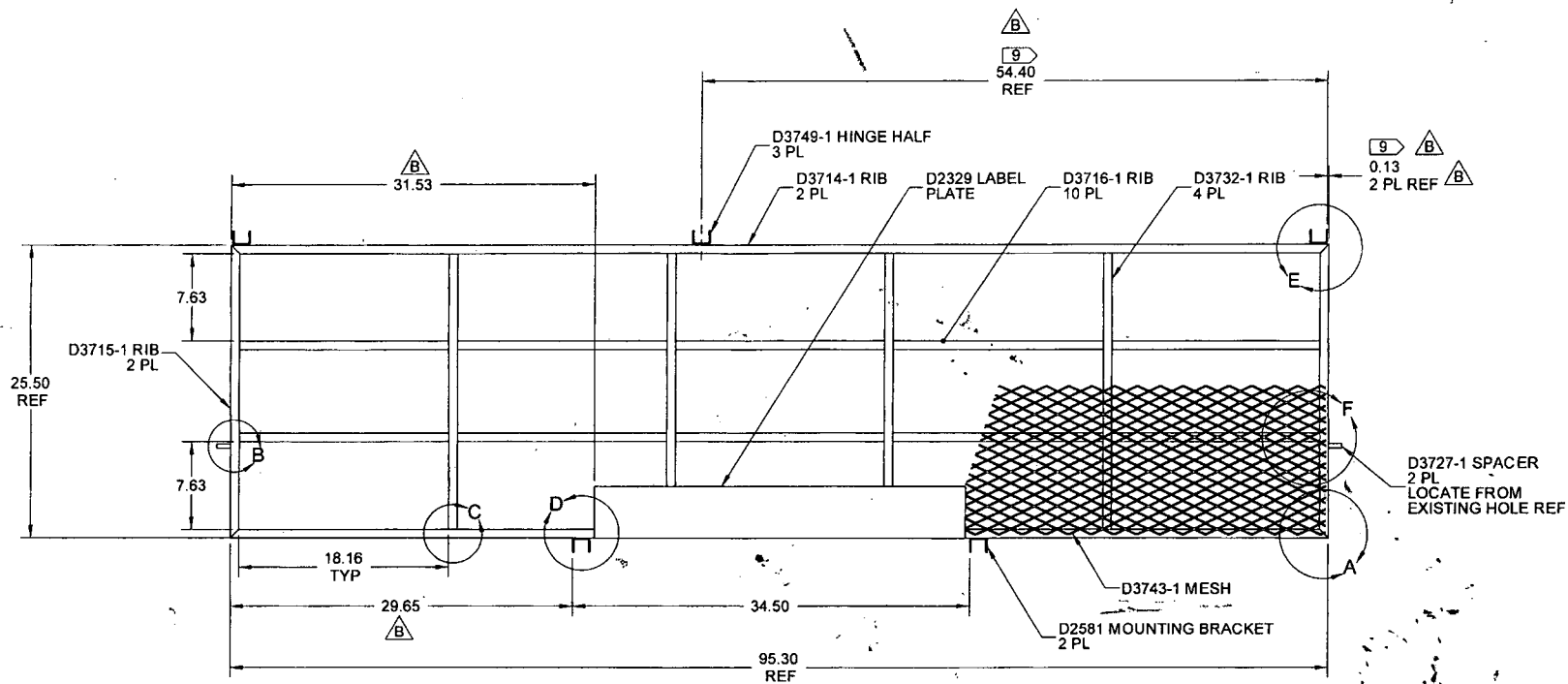


D3713-042 LID ASSEMBLY (SHOWN)
D3713-041 LID ASSEMBLY (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

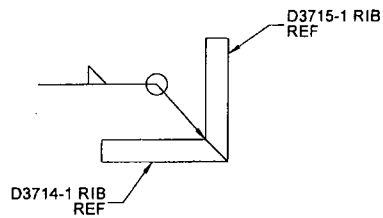
- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3 5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

B	SHEET 1 -042 WAS -041; ADDED CORRECT -041 ASSEMBLY. NOTE 9 ADDED. ZONE C2 LID ASSEMBLY WAS D3713-041. WEIGHT WAS 36 lbs. SHEET 2 ZONE B5 LID ASSEMBLY WAS D3713-041. ZONE D6 31.53 DIM WAS 31.64. ZONE D3 54.40 DIM NOW REF ZONE D2 0.13 REF DIM ADDED ZONE B6 29.65 DIM WAS 29.77. ZONE D3 & D2 FLAG NOTE 9 ADDED.	AJS	08.02.27
A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	CE		
MFG. APPR.	DS		
APPROVED	JP		
DE APPR.	JP		
DATE	08.02.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3713 TITLE LID ASSEMBLY REV. 8 SHEET 1 OF 3 SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

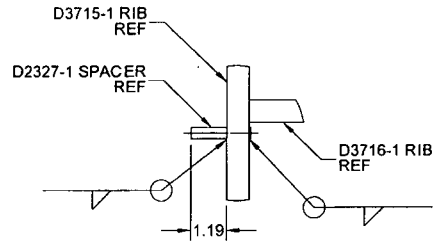


D3713-042 LID ASSEMBLY (SHOWN)
D3713-041 LID ASSEMBLY (OPPOSITE)
 (MESH SHOWN LOCALLY FOR CLARITY)

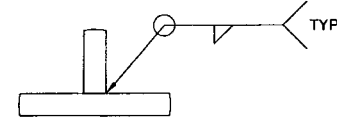
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	ME	D3713	SHEET 2 OF 3
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DE APPR.	ME	LID ASSEMBLY	NTS
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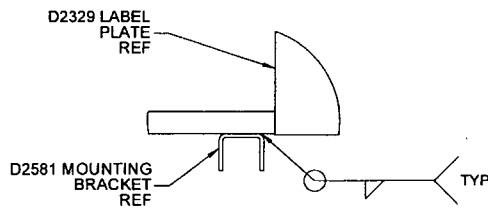
DETAIL A: TYP CORNER WELDS
SCALE 4X
(MESH NOT SHOWN FOR CLARITY)



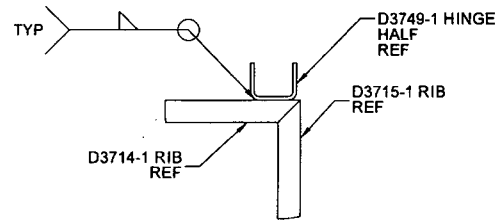
DETAIL B
TYP BOTH ENDS
SCALE 4X



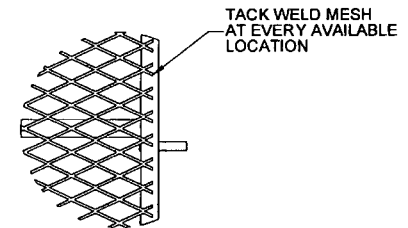
DETAIL C
TYP
SCALE 4X



DETAIL D
SCALE 4X



DETAIL E
SCALE 4X



DETAIL F
SCALE 5X

44377

110523-17-10P

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CHECKED	AYE	DRAWING NO. D3713	REV. B
MFG. APPR.	AYE	SHEET 3 OF 3	
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DE APPR.	AYE	LID ASSEMBLY	NTS
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L Lacelle

From: Sian Willems [swillems@dartaero.com]
Sent: January 5, 2009 10:23 AM
To: 'L Lacelle'
Cc: 'Dan Stow'; 'Bill Beckett'
Subject: HAI basket lid w/o 00574

Hi Linda,

As discussed, we'll need a flat lid for the med bell basket for HAI.

D3713-042 RH flat lid for med bell basket.

Need before first week of February.

Thanks,

Sian Willems

Marketing

T - 1.613.632.5200

F - 1.613.632.1185

C - 1.613.676.0577

swillems@dartaero.com

DART Aerospace Ltd.